

# Work Order ID 63412

October 29, 2010 12:14:06 PM

Page 1

Item ID: D3137-043

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 10/29/10 Start Qty: 1.00

Required Date: 10/29/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

140

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

PULL FROM STOCK:  
1 X D3137-043 B61481

DISASSEMBLE  
RETURN TO STOCK:  
1 X D3137-7 B61481  
1 X D3137-3 B61700  
1 X D3137-5 B46740  
DISCARD HARDWARE

u 10 10-29

160

Identify as per dwg & Stock Location: 232B

0.00



Packaging

Memo

0.00

Packaging

# Work Order ID 63412

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Item ID: D3137-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 10/29/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/29/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*Handwritten signature* 10.10.29

*Handwritten signature* 10.10.29

# Picklist Print

October 29, 2010 12:14:05 PM

Work Order ID: 63412

Parent Item: D3137-043

Parent Item Name: Bracket Assembly




Start Date: 10/29/10


Required Date: 10/29/10


Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:A 04.02.18 New issue KJ/DS  
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3137-3  Guide		Manufactured	No				Each	3.0000	1	-1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST235B			3						
					62560		3						
D3137-5  Washer		Manufactured	No				Each	3.0000	1	-1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST235B			3						
					61701		3						
D3137-7  Bracket		Manufactured	No				Each	3.0000	1	-1			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST235B			3						
					25556		3						

 3761700 10/29/10

 3746740 10/29/10

 41581 61481 10/29/10

# Picklist Print

Thursday, August 26, 2010 2:41:57 PM

Page 1

Work Order ID: 61481

Parent Item: D3137-043

Parent Item Name: Bracket Assembly




Start Date: 8/26/2010

Required Date: 9/6/2010

Start Qty: 12.00

Required Qty: 12.00

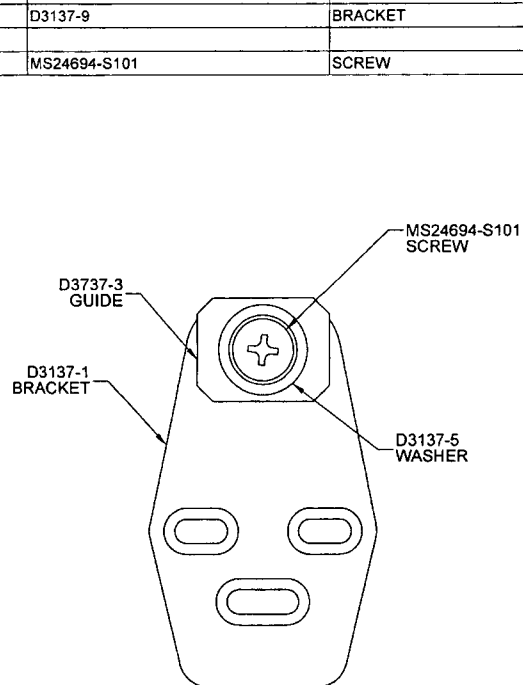
Comments: IPP Rev:A 04.02.18 New issue KJ/DS  
IPP Rev B 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS24694-S101  Screw		Purchased	No			100	Each	74.0000	1	12		8/30/09/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST290A		74							
					110363	74							
D3137-3  Guide		Manufactured	No			140	Each	6.0000	1	12		8/30/09/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		6							
					59634	6							
D3137-5  Washer		Manufactured	No			140	Each	13.0000	1	12		8/30/09/20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		13							
					46740	13							

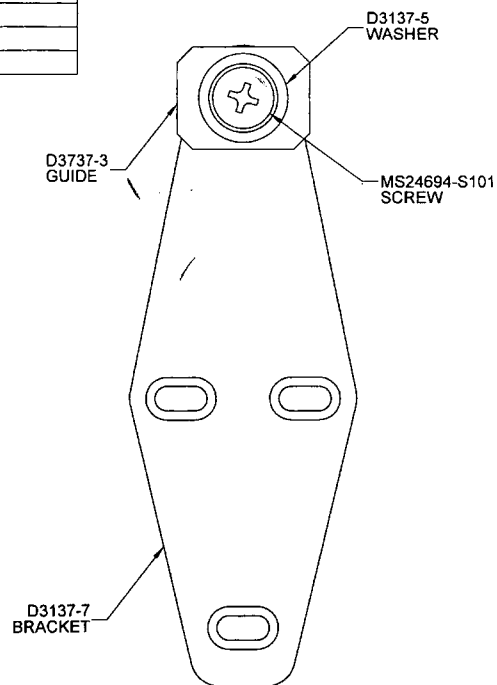
361700 (82)

63012

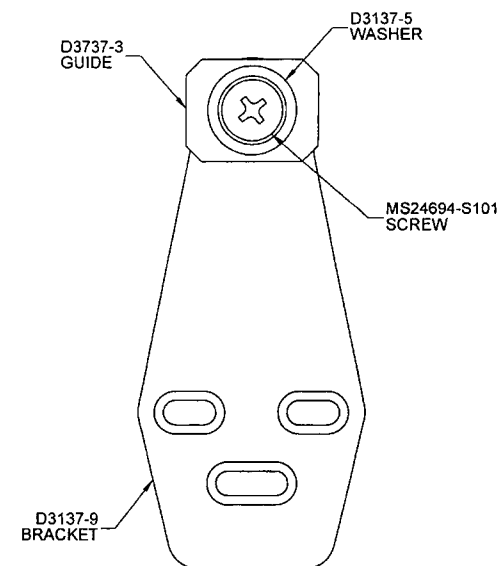
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



**D3137-045 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041  
: 0.32 lbs -043  
: 0.27 lbs -045

RELEASED  
08.06.16

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

# Work Order ID 61481

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Page 1

Item ID: D3137-043

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 8/26/2010 Start Qty: 12.00

Required Date: 9/6/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

REFERENCE ONLY

Approvals:

Process Plan:

Date:

10-8-26

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks: (.500" x 2.000") 5.570" long

0.00

0.00

8/10/09/04

12

8

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine D3137-7 as per Folio FA3308 and Dwg D3137 Identify as D3137-7  
2-Debur 3-Scribe batch number

0.00

0.00

8/10/09/05

12

8

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

8/10/07/05

12

8

**Work Order ID 61481**

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Page 2

Item ID: D3137-043

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 8/26/2010 Start Qty: 12.00

Required Date: 9/6/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M.A 10/09/16

12

0

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3137-043 as per Dwg D3137

8/30/09/20 (12)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/30/09/20

(412)

**Work Order ID 61481**

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Thursday, August 26, 2010 2:41:52 PM

Item ID: D3137-043

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 8/26/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>235B</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/9/20 sf 120

10.09.20

MF 10-9-20